

6061.750

Work Order ID 165398

165398

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Monday, August 21, 2017 2:56:51 PM

Item ID: D3490-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cross Bolt Spacer
 Start Date: 8/16/2017 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 8/24/2017 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: AUG 22 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3490	Rev A

100		0.76							
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100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

1-TURN AS PER FOLIO FA629 & DWG D3490

FOLIO REV: 11DWG REV: 1

2-DEBURR AS REQUIRED

1.04

22 ϕ DAS 23 9-89
 17/9/18

110		0.00							
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110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.20

22 ϕ DAS 23 9-89
 17/9/18

120		0.00							
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120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.40

22 ϕ DAS 49 9-89
 17/09/19

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
124		0.00							
124						22	Ø	8E1709-19	
HandFinish	Memo	1.42							
Hand Finishing	CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANER								
130	Identify as per dwg & Stock Location: LG001	0.00							
130						22	Ø	8E1709-19	
Packaging	Memo	0.20							
Packaging	***STOCK IN SKIDTUBE CELL*** LOCATION : LG001								
140	QC21- Final Inspection - Work Order Release	0.00							
140								17/9/2017	
QC	Memo	2.00							
Quality Control									

am

SEP 19 2017

Picklist Print

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Work Order ID: 165398

165398

Parent Item: D3490-3

D3490-3

Parent Item Name: Cross Bolt Spacer

Start Date: 8/16/2017

Required Date: 8/24/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased				100	f	20.8400	0.266	5.6			

M6061T6R0 750

**

6061-T6 Round Bar .750"

Location

Loc Qty

Loc Code

MAT012

20.84

m137400

5.25

m137513

15.59

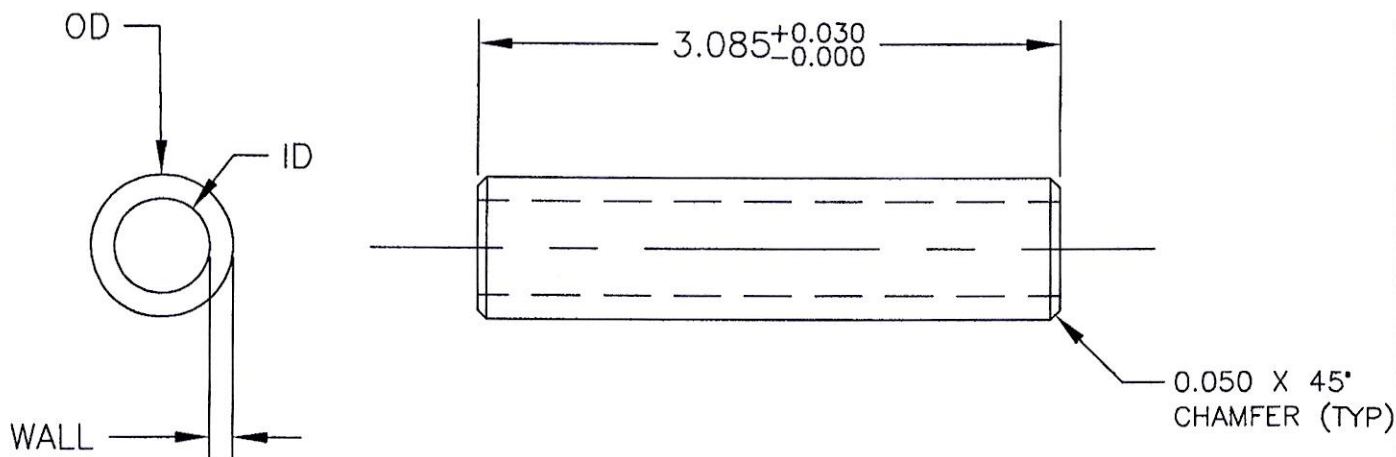
5.25
1.833

DAS
23
9-89

17/9/19



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	RE SHEET 1 OF
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 165398MCS
170822
RELEASED
06-02-07

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